Work Orde Wednesday, June				*120	309*						Page 1	L
Revision ID:	D3566-5 Gasket Cente	r Aft		Accept	*N90	<b>0040</b>	110	)* ·	Setup Sta	· · · · ·	IS1*	<del></del>
	6/04/14	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Ite Custome					* *	IS2*	
Approvals:	Process Pla	an: <u>M</u> Lゴ	Date: 14-00-06	Tooling: SPC (Y/N):		Date:		I	Run Sta Sto	νι <b>ν</b> .	R1*	
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool II	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr			<del>,</del>							_
D3566	Rev	/ C										
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	ot	FLOW WATER JET  Memo  1-Cut as per Deburr if nec	Dwg D3566 Dwg Rev:( cessary	0.00 0.00 Prog Rev:	2-			22	PROT		Mm 14	- 1/06/11
*110 * QC Quality Control		QC2- Inspect parts off ma	achine FAI/FAIB	0.00				22)			mm 1	14/06/10
120 *1 20*		QC8- Inspect parts - seco	nd check	0.00 PB 14/6/16 DAS 0.00 27				(22)	) 			
Quality Control				9-89				COUNT				

DQA:			Date:			•							TAART
						WORK ORDER NON	-CC	ONFO	RMANCE / UP		/		AEROSPACE
QA Closed:			Date:							VV	ork Order up	date only	
   Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac						Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•			•		Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo.					Suspected Unapproved	1		Large Fab	Composite	<u>]</u> .	Supplier	
			-										
Root					Desc	ription of work order update	ı	nitial	Actio	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design													
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Material													
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Offset/Setup	_					•							
Process													
Supplier		·											-
Training													
Transport	$\dashv$												
Unapproved			<u> </u>		<u> </u>		<u> </u>	III T CA	TECODY				
						<b>61</b>	FA	ULI CA	TEGORY		·		
Landir (						General		ارمانه (د	Program		Outside Dim	onsions [	Pressure/Forced
		Bending	-t C	.+-:-	$\vdash$	Bend BOM/Route	$\vdash$	Grain	riogrami	-	Over/Under	<u>-</u>	Set-up
	-	Centre No Cracks	ot concer	itric	$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa	oro	<u> </u>	Part Incorre	F	Temperature/Cure
		Cracks Crimp/Kii	nk/Binnlo	/\\/\	-	Burrs	$\vdash$	4	ion Incomplete/Un	nualified	Part Lost/Mi		Weld
	$\vdash$	Cuffs	ik/ kippie	/ vvave	-	Contamination	$\vdash$	4	tions Incomplete/U		Part Moved	-	Wrong Stock Pulled
		Crushing		•		Countersink	$\vdash$	4	gned/off center	-	Positioned V	L Vrong	
	$\overline{}$	Heat Trea			$\vdash$	Cut Too Short	$\vdash$	Mislabe			Power Loss/	· ·	Other
]		Inspectio		Tube		Drawing		Misrea		<u> </u>		~ L	
		Marks/Ch	•		-	Drill Holes		Off-set				·-	
		Turning S				Finish		4	Calibration				
		Wave/Tw				Fit/Function		-	Sequence				

	Work Order ID 120309 Wednesday, June 04, 2014 3:01:40 PM				*120	1309*						Page
Item ID: Revision ID: Item Name:	D3566-5 Gasket Cent	er Aft		. A	Accept	*N900	<u>040</u>	10	<b>0</b> *	Setup Star Stop	17	S1* S2*
Start Date: Required Date Reference:	6/04/14 e: 6/04/14	Start Qty: 20.00 Req'd Qty: 20.00		*20* *20*		Cust Item 1 Customer:	iD:			,	"IN	<b>.</b>
Approvals:	Process P QC:	lan:	Date:		Tooling: _ SPC (Y/N):		ate:		I	Run Star Stoj	<b>^ \</b>	R1* R2*
Sequence ID/ Work Center	ID .	Operation Description Identify as per dwg & Sto	ock Location:	FP-001	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120* Packaging		Memo		v	0.00				<u>y22</u>		- 41	40

140

Packaging

QC21- Final Inspection - Work Order Release

0.00

\*14**0**\*

Quality Control

Memo

0.00

M19 140612

Page 2

DQA:			Date:											TAAPT
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UF	PDATE		_		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
NA / a ml : O mal a						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Orde	er: _				—	Rework	1 Ì		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	$\vdash$	Quality
i diciv	-					Use-as-is	1		noforming	Finishing	-	e/Packaging	Н	Other
NCR N	lo.					Suspected Unapproved	1 1		Large Fab	Composite	1	Supplier	_	
	•						'		° Ш		<b>_</b>			
Root					Desc	ription of work order update	l	nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling									:					
Handling/Pre	_												,	
Material	_							•					,	
Operator	$\dashv$											:		
Offset/Setup														
Process	ᅴ										1.	i		
Supplier														
Training	$\dashv$										•			
Transport Unapproved	$\dashv$													
Ollappioved	1		<u>.                                    </u>		l		FA	ULT CA	TEGORY					L
Landir	ng G	iear				General				<del>* *</del> ·		<u></u>		
Г	$\overline{}$	Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
<b> </b>		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	લ		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	-	Weld
[		Cuffs				Contamination		4	tions Incomplete/U	Inclear	Part Moved		L	Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center	<u>_</u>	Positioned V		_	1
		Heat Trea				Cut Too Short		Mislabe			Power Loss/	Surge	L	Other
[ ]	_	Inspectio		Tube	·	Drawing	<u> </u>	Misrea						
	Ш	Marks/Ch			_	Drill Holes	$\vdash$	Off-set				<del></del>		
	Turning Sequence				Finish	<u></u>	-1	Calibration				_		
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

Wednesday, June 04, 2014 3:01:38 PM

Work Order ID: 120309

\*120309\*

Parent Item:

D3566-5

\*D3566-5\*

Parent Item Name:

Gasket Center Aft

**Start Date:** 6/04/14

Required Date: 6/04/14

**Start Qty: 20.00** 

Required Qty: 20.00

**Comments:** 

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

Added Drain Holes 07-07-09 JLM

IPP Rev:C

As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	707.9900	1.06	23.55556			
*MNF060	C UE3*								**			u.L	. 1
				T		Ŧ.,	24				$-\sigma \sim$	19/8	6/06
NEOPRENE SHEET 0.063				Location		<u>Loc (</u>	<del></del>	Loc Code	_		$ \sim$ $\sim$ $\sim$	<u>, 1478</u>	6/26_
				Location MAT052		-	<u>Qty</u> 7.99	Loc Code	_		<u>_</u>	<u>, 1478</u>	6/06
				MAT052	м126546	70	<del></del>	Loc Code	_		$-\infty$	<u>, 1978</u>	6/06_
				MAT052	M126546 M128266	70	7.99	Loc Code	- - -		<i>σ</i> \ <i>ρ</i>	<u>, 1978</u>	6/06_

DART							Date:		·	DQA:
e only	ork Order update only		CONFO	WORK ORDER NON-			Date:		d:	QA Closed
OCESS	EPARTMENT/PROCESS	AGAINST DE		DISPOSITION					rder:	Work Or
	Water Jet Prod. Eng. Coor.	Skid-tube Crosstube Machining Small Fab		Rework Scrap					t No.	
	Rec/Store/Packaging	noforming Finishing Large Fab Composite		Use-as-is Suspected Unapproved					R No.	
	Sign &	Action	Initial	ription of work order update	Desc					Root
erification QC Inspector	Date Verification	Description	Chief Eng	or non-conformance	y	Qty	Step	Date		Cause
									re	Design Doc/Data Equip/Toolin Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport
		regory	AULT CA			1	]		<u>~</u>	опаррточец
				General				Gear	nding G	Lan
rance Set-up Temperature/Cure Weld Wrong Stock Pulled	Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	ion Incomplete/Unqualified ions Incomplete/Unclear gned/off center eled d	Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set Out of	Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		/Wave	nk/Ripple nt n Strip in natter equence	Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspectio Marks/Cr		
rand g	Over/Under tolerand Part Incorrect Part Lost/Missing Part Moved Positioned Wrong	rogram  ire  ion Incomplete/Unqualified ions Incomplete/Unclear gned/off center eled	Folio/F Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set	General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		/Wave	nk/Ripple nt n Strip in natter equence	Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch	d Inding G	Operator Offset/Setup Process Supplier Training Transport Unapproved

DART AEROSPACE LTD	Work Order:	120307
Description: Gasket	Part Number:	D3566-5
Inspection Dwg: D3566 Rev: C		Page 1 of 1

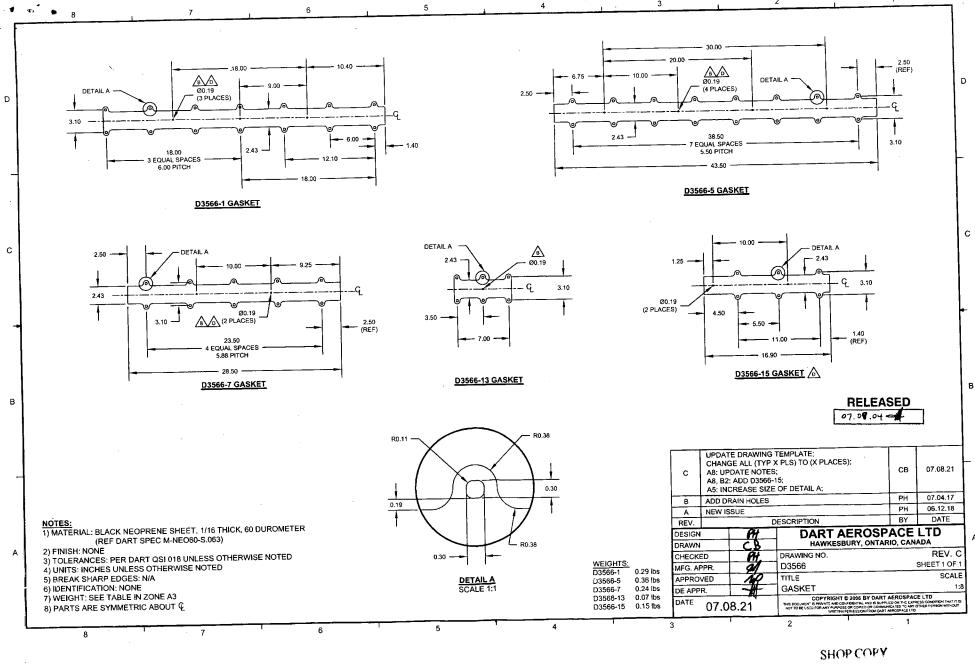
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.50	+/-0.030	38.50			V- 5km-01	
43.50	+/-0.030	43.50			T-5km-66	
5.50 Pitch	+/-0.030	5.50				
2.50	+/-0.030	2.50		ļ		
2.43	+/-0.030	2.43				
3.10	+/-0.030	3.10				
2.50	+/-0.030	2.50				
0.30	+/-0.030	1,30				
0.30	+/-0.030	0.30				
0.063	+/-0.010	0,063				
6.75	+/-0.030	6.75				
10.00	+/-0.030	10,00		· ·		
20.00	+/-0.030	20.00				
30.00	+/-0.030	30.00				
Ø0.19	+/-0.030	0.19				

Measured by: 000	Audited by:	EB.	DAS	Prototype Approval:	N/A
Date: JY/06/11	Date:	14/6/11	9-89	Date:	N/A

1		B.1.	Change	Revised by	Approved
- 1	Rev	Date	Change	KJ/JLM	
	A	07.03.14	New Issue		-
		07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
•				KJ/JLM	
	С	07.09.06	Ø0.188 dimension removed	KJ/EC/DD	1/1
		08.01.16	Dwg Rev updated	KILCIDDE	
	D	08.01.16	Dwg Rev updated	· · · · · · · · · · · · · · · · · · ·	



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